

Work Order ID 57448

April 7, 2010 9:53:32 AM



Page 1

Item ID: D3773-041

Accept



Setup Start



Revision ID:

Item Name: Headrest Assembly

Stop



Start Date: 07/04/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: 14 Date: 10-4-07 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3773	Rev B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773 ****take dowel pin out before welding****2- weld as per dwg D3773 QSI004 316 S.S. Welding Rod Batch: <u>12111679</u> 3- if necessary grind interior of D3773-3 leg Flush after welding.								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

10.05.31 4

10.05.31 4

10.05.31

10.05.31

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00							④ 10.05.31
140 	Identify as per dwg & Stock Location <i>C-A 3X</i>	0.00							
Packaging Packaging	Memo <i>Store ⑩</i>	0.00							<i>ES 10/06/01 ④</i>
150 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<i>10/06/01</i> <i>CL 10/06/11</i>

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Picklist Print

April 7, 2010 9:53:36 AM

Page 1

Work Order ID: 57448

Parent Item: D3773-041

Parent Item Name: Headrest Assembly



Comments: IPP Rev:A 08-05-21 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3773-1		Manufactured	No			100	Each	2.0000	3.0000			
											10.05.31	
Adapter												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA 857557
54799

2

2

4

D3773-3

Manufactured No

110

Each

1.0000

3.0000



Leg



10.05.31

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA 857558
56862

1

1

4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

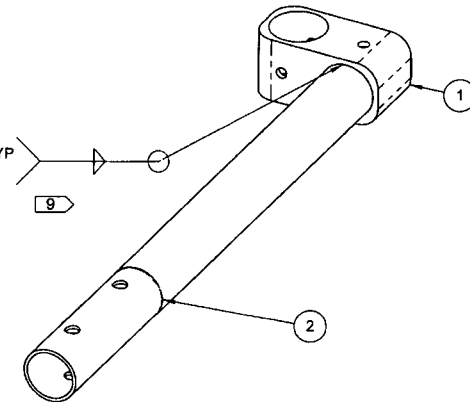
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NOTE: Date & initial all entries

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57448

RL10-4-07

0.08 TYP
2 PL
9



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

D3773-041 HEADREST ASSEMBLY

NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.06.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3773** REV. B
SHEET 1 OF 3
TITLE **HEADREST ADAPTER** SCALE NTS

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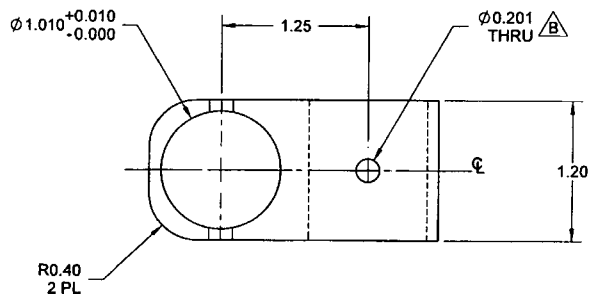
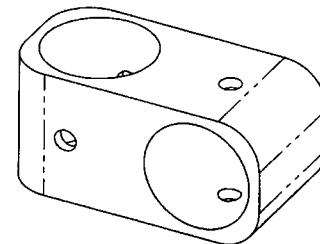
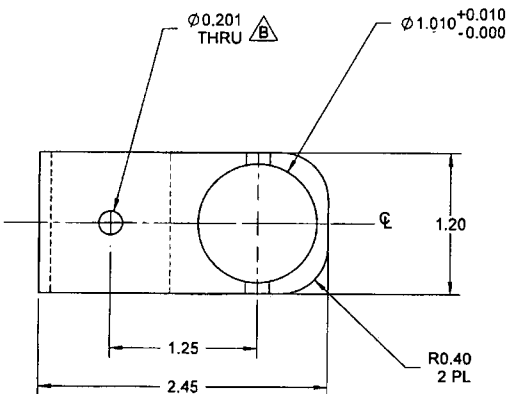
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NOTE: Date & initial all entries



D3773-1 ADAPTER

W/O 57448

RELEASED
08-07-10

NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

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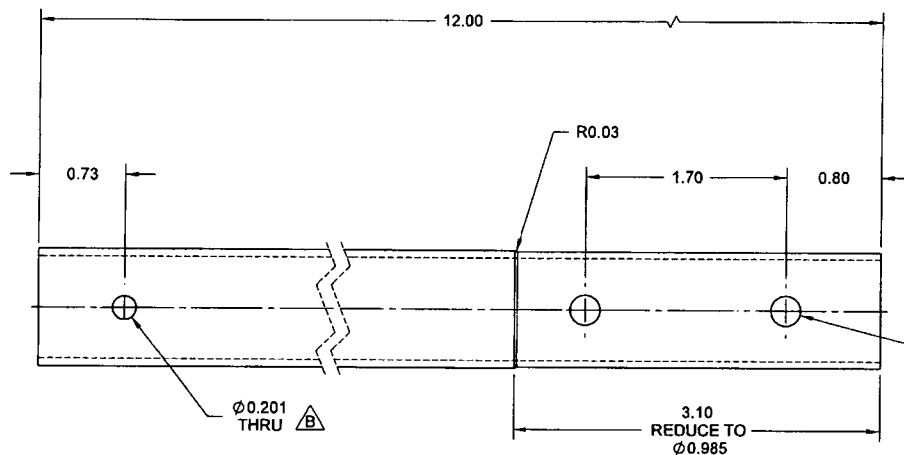
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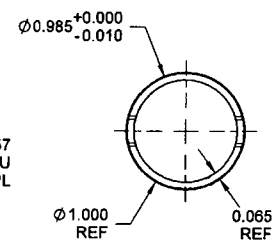
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NOTE: Date & initial all entries



D3773-3 LEG



W/O 57448

RELEASED
08-07-10 M/D

- NOTES:
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HEADREST ADAPTER	NTS
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